

Date: Wednesday, 18/02/2009 2:59:29 PM
 User: Julie Dawson

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : FRONT INBOARD LEG ASSEMBLY
Job Number : 45878	
Estimate Number : 13320	
P.O. Number :	Part Number : D3782041
This Issue : 18/02/2009 S.O. No. :	Drawing Number : D3782 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 42840	Material :
Written By :	Due Date : 25/02/2009 Qty: 4 Um: Each
Checked & Approved By : <u>JUD 09.02.18</u>	
Comment : Est Rev:A 08-05-19 new issue DD verified by:ec Est Rev:B 08-06-17 rev.A as per dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0	D37681	Front Inboard Leg
-----	--------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Front Inboard Leg
 batch: 42959

(4)

FF 09-04-13

3.0	D37871	Foot
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Foot
 batch: B41880

(4)

FF 09-04-13

4.0	AN513A	Bolt
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Bolt
 batch: M110363

(4)

FF 09-04-13

5.0	AN960JD516	Washer
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)
 Washer
 batch: M110523
 or (NAS1149D0568J)batch: _____

(4)

FF 09-04-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/02/2009 2:59:29 PM
User: Julie Dawson

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: FRONT INBOARD LEG ASSEMBLY

Job Number: 45878

Part Number: D3782041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

batch: M109840

FF 09-04-13

(4)

7.0

AN45 13A

EYE BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

eye Bolt

batch: M109712

FF 09-04-13

(4)

8.0

D3762041

Front Leg Fitting Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Front Leg Fitting 42230x1 / 42947x3

FF 09-04-13

(4)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-assemble as per dwg D3782

****install AN45-13A eye bolt as shown for D412-769-041****

****install AN45-13A eye bolt in reverse for D412-769-042****

FF 09-04-13

(4)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/04/13

(4)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 249

9/4/14

SO

FF (4)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/14

Job Completion



W B 04/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

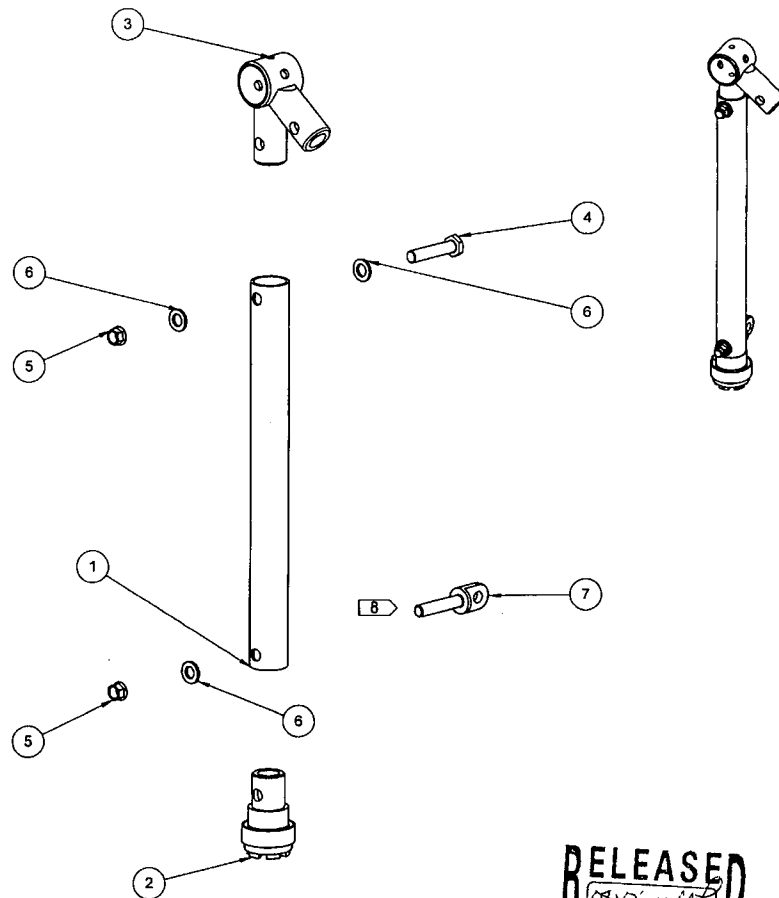
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3788-1	FRONT INBOARD LEG	1
2	D3787-1	FOOT	1
3	D3762-041	FRONT LEG FITTING ASSY	1
4	AN5-13A	BOLT	1
5	MS21042L5	NUT	2
6	NAS1149D0568J	WASHER (AN960JD516)	3
7	AN45-13A	EYE BOLT	1



D3782-041 FRONT INBOARD LEG ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs
- 8) ITEM 6 (AN45-13A EYE BOLT) INSTALLED AS SHOWN FOR D412-769-041 AFT FACING SEAT, LH
INSTALLED IN REVERSE FOR D412-769-042 AFT FACING SEAT, RH

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 NO 45878

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A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS		
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MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.06.04		

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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3768-3	FRONT OUTBOARD LEG, LH	1
2	D3787-1	FOOT	1
3	D3762-041	FRONT LEG FITTING ASSY	1
4	AN45-13A	EYE BOLT	2
5	MS21042L5	NUT	2
6	NAS1149D0568J	WASHER (AN960JD516)	2

D3782-043 FRONT OUTBOARD LEG ASSY, LH

NOTES:

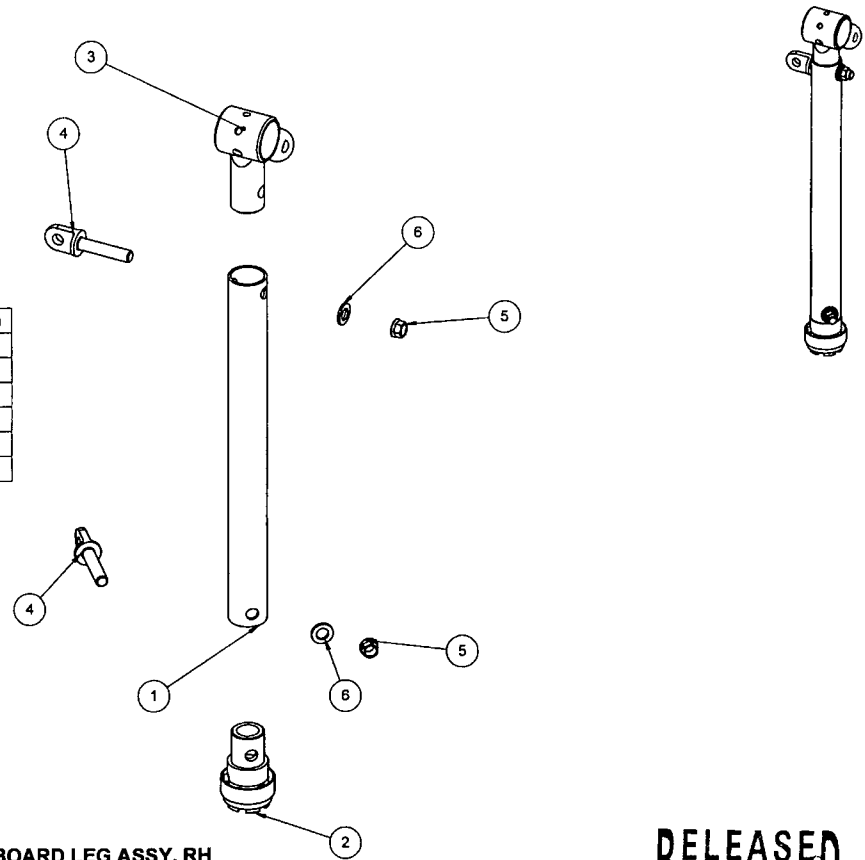
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs

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NO. 45878

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DATE	08.06.04		

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3768-4	FRONT OUTBOARD LEG, RH	1
2	D3787-1	FOOT	1
3	D3782-041	FRONT LEG FITTING ASSY	1
4	AN45-13A	EYE BOLT	2
5	MS21042L5	NUT	2
6	NAS1149D0568J	WASHER (AN960JD516)	2



D3782-044 FRONT OUTBOARD LEG ASSY, RH

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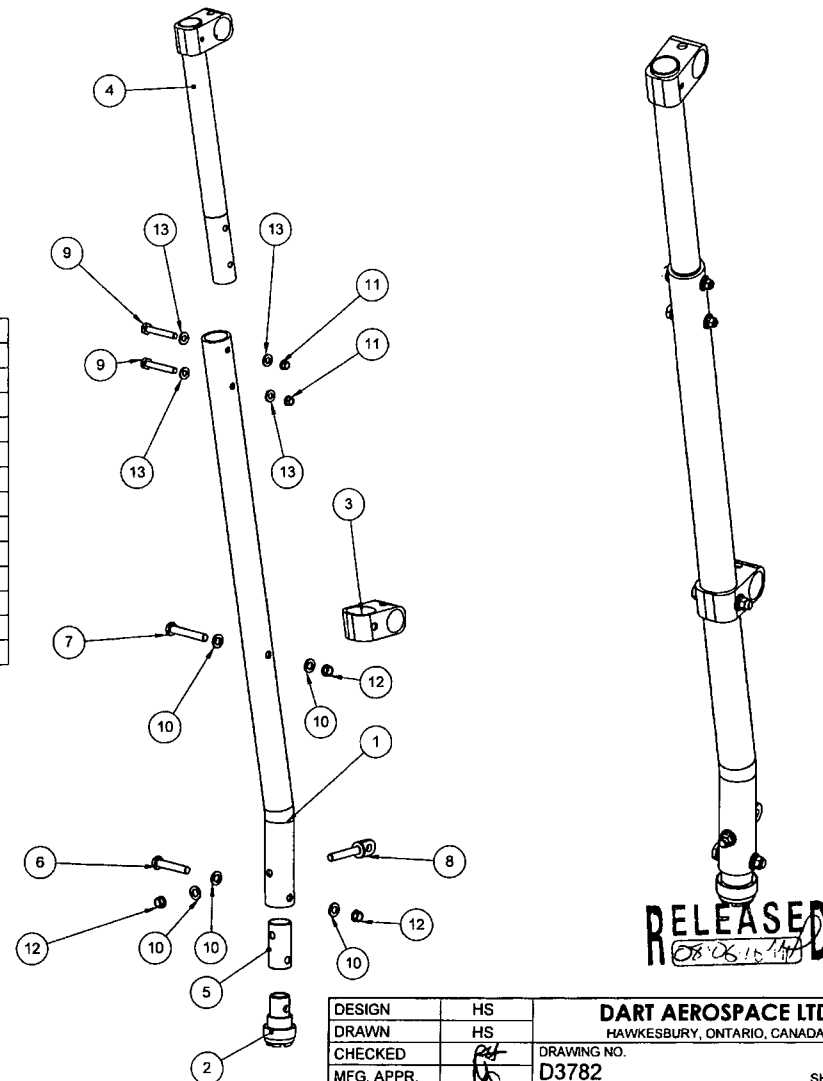
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- NOTES:**
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.42 lbs

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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-045)
1	D3772-1	BACK LEG	1
2	D3787-1	FOOT	1
3	D3764-1	BACK LEG FITTING	1
4	D3773-041	HEAD REST ADAPTER ASSY	1
5	D3786-1	SLEEVE	1
6	AN5-15A	BOLT	1
7	AN5-17A	BOLT	1
8	AN45-15A	EYE BOLT	1
9	AN4-15A	BOLT	2
10	NAS1149D0568J	WASHER (AN960JD516)	5
11	MS21042L4	NUT	2
12	MS21042L5	NUT	3
13	NAS1149D0463J	WASHER (AN960JD416)	4

D3782-045 BACK LEG ASSY



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NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 4.71 lbs

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